



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBD29822-3
Job Sheet 201784



Part No: RBD29822-3

Job Qty: 1 pcs *5 pcs*

Part Name: Tail Rotor Swash Plate Holding Block



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBD29822 Rev 2 IPP Rev. A 19.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	NV5000 - 1	1 pcs	11/29/19		1.00	1.00	NV5000 - 1	<i>ML 19/11/21</i>
							NV5000 - 2	
110	QC 2	1 pcs	11/29/19		0.00	0.00	QC 2 - 1	<i>ML 19/11/21</i>
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Container No: S233799



Part: RBD29822-3

Job No: 201784

Serial No/Batch: S233799

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/21/19

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120 QC 8	1 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	DAS
				QC 8 - 23	23
				QC 8 - 57	9-89
				QC 8 - 76	
				QC 8 - 61	
					19/11/21
125 Outsource - 4 - Anodize	1 pcs	11/29/19		GRO002-VC	2019-11-22
126 Packaging 2-1 - Receive - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	

				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
127 QC 6	1 pcs	11/29/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	DAS DEC 04 2019 40 9-89
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 DEC 05 2019 GA 146A

140 QC 21 - FG 1 pcs 11/29/19 0.00 0.00

Part Op 100 - 1-Machine as per folio F0083 FOLIO REV: AA DWG REV: 2 2-Debur

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

125 - -Issue P/O; 45181 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -
Material type; 6061T6 -Certificate of Conformity is required

126 - C of C required.

127 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X03.500	6061-T6 Bar 2.00 X 3.50	.6500 ft (.65 ea)	100-NV5000 - 1	<u>S20 1866</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	M6061T6B2.000X03.500	1	8	0
	<u>7.700</u>			

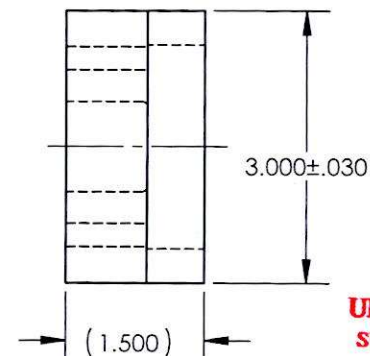
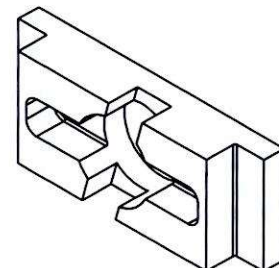
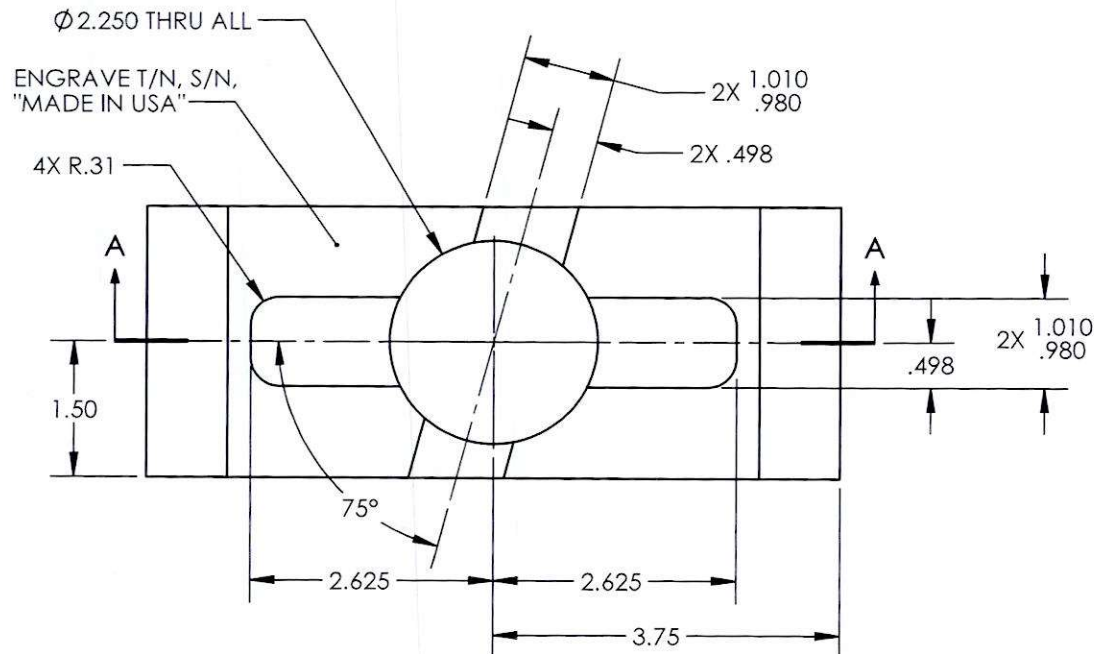
Part Specifications

Specifications could not be found.

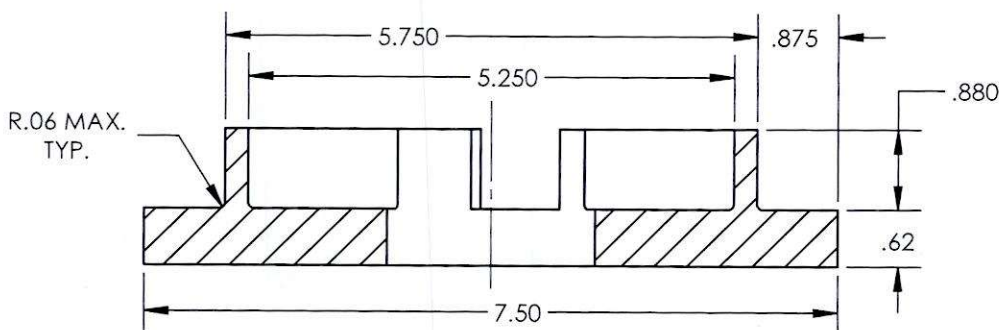
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D TITLE BLOCK & REVISION BLOCK. ADDED ENGRAVE NOTE P/N -5, MOVED P/N -3 TO SEPARATE DWG. TOOLS ARE SOLD SEPARATELY.	12/7/2009	RJC	RW
2	17-0141	CH'D DIM'S WAS (x4) R.310 IS 4X R.31, WAS 1.500 IS 1.50, WAS 3.000 IS 3.000±.030, WAS .620 IS .62, WAS 3.750 IS 3.75, WAS 7.500 IS 7.50, WAS 2 PLACES WAS 1.010/.980 IS 2X 1.010/.980, WAS .500 IS 2X .498, ADDED DIM (1.500). CH'D NOTE WAS STAMP IS ENGRAVE T/N, S/N, "MADE IN USA". ADDED FINISH SPEC MIL-A-8625F, TYPE II, CL II. ADDED USED ON MODEL NOTE.	6/19/2017	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OR
NO. 201784 MWS
19-10-10**



SECTION A-A

NOTE:
USED ON MODELS: HUGHES 269, TH-55,
SCHWEIZER 300 SERIES.

DART AEROSPACE	
TITLE HOLDING BLOCK	
DWG NO. RBD29822-3	REV 2
MAT'L 6061 HEAT TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: DD 06/19/2017 OPPTS APPR: AA 06/20/2017 QA APPR: JL 06/28/2017 APPROVED: JAG 07/03/2017	
USED ON MODEL	
SCALE 1:2	DATE 3/29/2006
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	HOLDING BLOCK	6061		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045181**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045181

PO Date: 11/22/19

Due Date: 12/2/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-25

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201784	RBD29822-3	RBD29822 Rev 2	Tail Rotor Swash Plate Holding Block -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type: 6061T6 -Certificate of Conformity is required	Firmed	-	12/2/19	5 pcs	0 pcs	5 pcs	\$8.5714/pcs	\$42.86
2	196989	D5312-1	D5312 Rev A	Tie Down Bracket : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1), 1-Create P/O: 2-STRIP AND RE ANODIZE 3-FINISH ANODIZE BLACK AS PER DWG AND NOTE 2.	Firmed	-	12/2/19	9 pcs	0 pcs	9 pcs	\$10.7936/pcs	\$97.14
Grand Total:												\$140.00

Guerin



Dart Aerospace Ltd.
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PURCHASE ORDER
POHB045181



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/25/19 12:56 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(024385-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

024385-1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
27-Nov-2019		Jigar Patel		POHB045181					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC / NC Qty		Qté Scrap/	À venir / Back Order
1	RBD29822-3 Rev.2	RBD29822 ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE - 2, CLASS - 2 WATER SEALANT	ANODIZE CH	5	5	0	0	0	0
2	D5312-1 Rev.A	D5312 STRIP ANO-BLACK [ANODIZE BLACK] MIL-8625F TYPE - I OR IB OR IC OR II OR IIB CLASS - 2 AS PER QSI017 4.1.10.1 AS PER DRAWING AND NOTE - 2	ANODIZE CH	9	9	0	0	0	0
3	STRIPPING CHARGES Rev.	STRIPPING CHARGES STRIP	STRIP LOT	9	9	0	0	0	0

RECEIVED
 NOV 28 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.